In the Claims:

Cancel claims 1 - 9 and substitute the following new claims:

10. (New) A method of controlling the pivoting movement of a teeming ladle about a fulcrum relative to a mold of a substantially linear array thereof and provided in a first teeming machine adapted to be moved in a first direction parallel to the array, the ladle comprising a spout provided with a teeming channel of predetermined radius and defining the fulcrum, comprising the steps of:
moving the mold toward the mold in a second direction substantially normal to the first direction;
lifting the mold in a direction substantially vertically relative to the first and second directions; and
pivoting the mold about an axis extending substantially normal to the second direction.

11. (New) The method of claim 10, wherein he moving, lifting and pivoting movements are executed by motors controlled by electronic control means.

12. (New) The method of claim 11, further comprising a second teeming machine adjacent the first teeming machine for continuing the teeming operation when the ladle of the first teeming machine is empty.

13. (New) A teeming machine, comprising:
a first carriage mounted for movement in a predetermined direction relative to an array of molds;
a second carriage mounted on the first carriage for movement relative to the array of molds in a direction substantially normal to the predetermined direction;

a structure extending upwardly from said second carriage and supporting retaining means for movement vertically of the structure;
a suspension plate mounted on the retaining means;
means for pivoting the suspension plate about an axis extending substantially normal to the movement of the second carriage;
a teeming ladle mounted on the suspension plate and provided with a teeming spout directed toward the molds.

14. (New) The machine of claim 13, further comprising a first motor for moving the second carriage, a second motor for vertically moving the retaining means and a third motor.for pivoting the suspension plate.

15. (New) The machine of claim 14, further comprising a programmable electronic control for controlling the movements of the first, second and third motors.

16. (New) The machine of claim 13, wherein the suspension plate and the teeming ladle are provided with complementary mounting brackets for removably mounting the teeming ladle on the suspension plate.

17. (New) The machine of claim 13, further comprising pressure gauges intermediate the structure and the control means for terminating the teeming operating in response to changes in the weight of the teeming ladle.

18. (New) The machine of claim 13, wherein the spout of the teeming ladle is provided with an exchangeable spouting stone.

19. (New) The machine of claim 13, wherein the teeming ladle is provided

All cont'd B1 cont'd with a slag brick adjacent to the spout stone.

Respectfully submitted,

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